

Tuesday, October 18, 2016 4:15:33 PM

Page 1

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
2AC 3 20-0								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 152019

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152019

Page 2

Item ID: D412-786-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Hardpoint Installation

Start Date: 10/18/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-786-013								
	Location: _____								
	PPP Rev: <u>PPP152018</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

1x **DAS 28** **DAS 27** NOV 16 2016
9-89 9-89

DAS 21 NOV 16 2016
9-89

DAS 21 NOV 16 2016
9-89

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
OTHER : _____																																																															

Picklist Print

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Page 1

Work Order ID: 152019

152019

Parent Item: D412-786-013

D412-786-013

Parent Item Name: Fwd Hardpoint Installation

Start Date: 10/18/2016

Required Date: 10/24/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-04-27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3870-041 *D3870-041* Hardpoint, Fwd LH		Manufactured	No				Each	2.0000		1		DAS 26 9-89	DAS 27 9-89
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST056	2							
					148941	2				IX			OCT 19 2016
D3870-042 *D3870-042* Hardpoint, Fwd RH		Manufactured	No				Each	2.0000		1		DAS 26 9-89	DAS 27 9-89
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST056	2							
					148850	2				IX			OCT 19 2016
D3870-5 *D3870-5* Mount, Fwd Upper		Manufactured	No				Each	0.0000		1		DAS 26 9-89	DAS 27 9-89
										152021			
D3871-1 *D3871-1* Doubler		Manufactured	No				Each	1.0000		1		DAS 26 9-89	DAS 27 9-89
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST056	1							
					149859	1				IX			OCT 19 2016
D3871-2 *D3871-2* Doubler		Manufactured	No				Each	1.0000		1		DAS 26 9-89	DAS 27 9-89
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST056	1							
					149860	1				IX			OCT 19 2016

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : ☐							

Picklist Print

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Work Order ID: 152019

152019

Parent Item: D412-786-013

D412-786-013

Parent Item Name: Fwd Hardpoint Installation

Start Date: 10/18/2016

Required Date: 10/24/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

Each

1,536.000

10

MS21042L3

Nut

**

DAS
26
9-89

DAS
27
9-89

OCT 19 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

7

M130922

7

GA

225

m134360

108

m135135

117

OVER007

600

m135767

600

ST303

704

m135530

600

m135600

104

Each

59.0000

8

**

DAS
26
9-89

DAS
27
9-89

OCT 19 2016

MS27039-1-11

Purchased

No

MS27039-1-11

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

20

125654

13

9662

7

ST280

39

m134738

39

Each

88.0000

1

**

DAS
26
9-89

DAS
27
9-89

OCT 19 2016

MS27039-1-12

Purchased

No

MS27039-1-12

Screw

DAS
28
9-89

Location

Loc Qty

Loc Code

ST280

88

m135566

88

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Tuesday, October 18, 2016 4:15:32 PM

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Work Order ID: 152019

152019

Parent Item: D412-786-013

D412-786-013

Parent Item Name: Fwd Hardpoint Installation

Start Date: 10/18/2016

Required Date: 10/24/2016

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-14

Purchased

No

Each

707.0000

1

68-6
92
SAS

DAS

MS27039-1-14

Screw

**

DAS

27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

94

120449

94

over006

499

124326

499

ST280

114

124326

114

Each

1,189.000

10

68-6
92
SAS

DAS

NAS1149D0332J

Purchased

No

NAS1149D0332J

Washer

**

DAS

27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

CA

6

m129682

6

FP001

196

m134848

196

GA

222

m134848

222

ST260a

600

m135672

600

ST264

165

m135536

31

m135566

134

OCT 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																	
		OTHER : ☐																							

Work Order ID 152019

Wednesday, October 19, 2016 3:05:52 PM

152019

Page 1

Item ID: D412-786-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Hardpoint Installation

Start Date: 10/18/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/24/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D412-786-1

C

DAS
21
9-89

OCT 19 2016

Label

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

DAS
21
9-89

OCT 20 2016

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D412-786-013 chg001

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

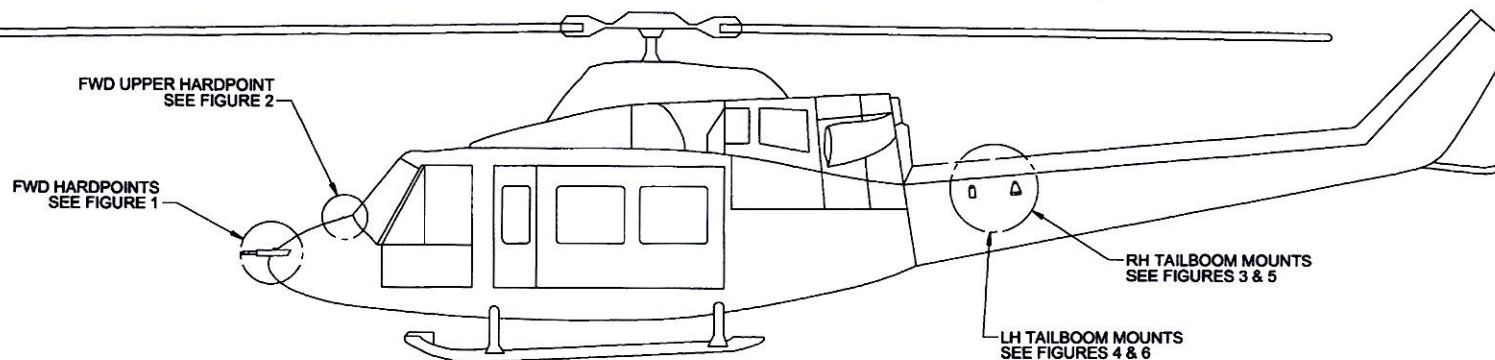
QC

Memo

0.00

Quality Control

REFERENCE ONLY



D412-786-011/-021 HARDPOINT KIT

QTY -011	QTY -013	QTY -015	QTY -021	QTY -025	PART NUMBER	DESCRIPTION
X					D412-786-011	HARDPOINT KIT
1	X		1		D412-786-013	FWD HARDPOINT KIT
1		X			D412-786-015	TAILBOOM MOUNT KIT
			X		D412-786-021	HARDPOINT KIT
			1	X	D412-786-025	TAILBOOM MOUNT KIT
		1			D3866-041	TAILBOOM MOUNT
		2			D3866-043	TAILBOOM MOUNT
	1				D3870-041	FWD LH HARDPOINT
	1				D3870-042	FWD RH HARDPOINT
	1				D3870-5	FWD UPPER HARDPOINT
	1				D3871-1	DOUBLER
	1				D3871-2	DOUBLER
				1	D4950-041	TAILBOOM MOUNT
				2	D4950-043	TAILBOOM MOUNT
	10	12		12	MS21042L3	NUT
	8	12		12	MS27039-1-11	SCREW
	1				MS27039-1-12	SCREW
	1				MS27039-1-14	SCREW
	10	24		24	NAS1149D0332J	WASHER

NOTES:

- 1) D412-786-011/-021 HARDPOINT KIT REQUIRED ON 412/412EP AIRCRAFT UTILIZING D412-695-011 BLADE FOLDING KIT WHERE WIRE STRIKE COMPATABILITY IS REQUIRED
- 2) D412-786-021 HARDPOINT KIT REQUIRED ON AIRCRAFT EQUIPPED WITH BLR TAILBOOM STRAKE KIT
- 3) TOUCH UP ALL DRILLED HOLES AND TRIMMED ALUMINUM PARTS WITH ALODINE 1201. THEN PRIMER PER THE AIRCRAFT MAINTENANCE MANUAL
- 4) TORQUE FASTENERS AS FOLLOWS: 10-32; 20-25 IN-LBS
- 5) PRIME AND PAINT HARDPOINTS TO MATCH AIRCRAFT PAINT SCHEME PER AIRCRAFT MAINTENANCE MANUAL

RELEASED
2016-09-09
EN 16-699

REV.	DESCRIPTION	BY	DATE
D	SHT 1 UPDATE WORDING OF NOTE 3 FOR TRIMMED PARTS. SHT 7 ADD DETAIL E AND SECTION F-F (SEE PAR 16-501). WEIGHT AND BALANCE INFORMATION MOVED TO SHT 8.	AJS	16.06.07
C	MODIFY D3870-5 INSTALLATION INSTRUCTION. ADD TO NOTE 2, SH 3 AND CLARIFY/ CORRECT VIEW C-C (ZN A8-3, C3-3).	DB	14.04.28
B	ADD -021/-025 KITS, SHEETS 6 & 7	DB	13.10.17
A	NEW ISSUE	HS	09.01.14
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	N/A	D412-786-1	SHEET 1 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	N/A	HARDPOINT KIT INSTALL	NTS
DATE	16.06.07	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED